

## JIG DESIGN

concave surface on an unusual piece. The work is clamped against the pads *A* and *B*, on previously milled surfaces, by means of two differentially operated plungers *C* and *D*, similar to a previously described device. To prevent springing under cut, the work is backed up with the floating plunger *E* on the one side and *F* and *G* on the other. The plungers are operated by push-rods *H* and *J*. These push-rods are hand operated and are clamped by the bushing *K* and star knob *L*.

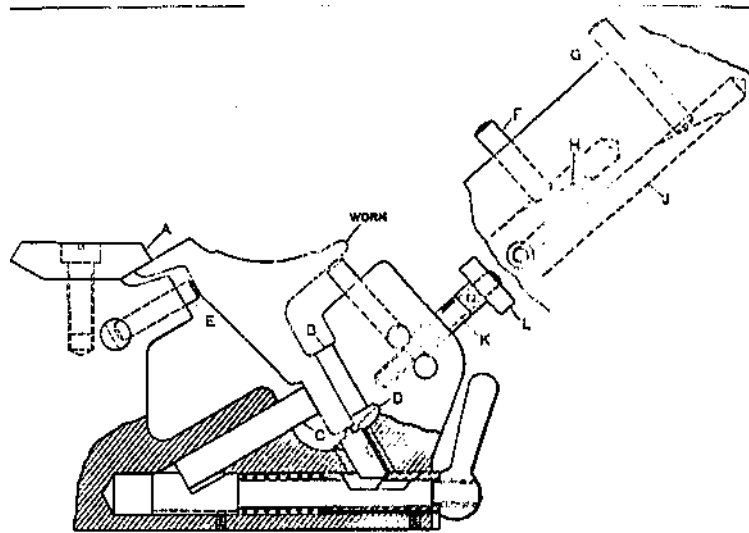


Fig. 22. Fixture for Milling a Concave Surface provided with Sliding Supports under the Milled Surface

Some occasions arise in which the 45-degrees plungers do not permit of sufficient clamping movement. The mechanism in Fig. 23 was designed to overcome this objection. An unusually large movement of the clamp is required to clamp directly over the rest-pin. Rod *A*, operated by screw *B*, imparts movement to both plungers *C* and *D*. Plunger *C* pulls clamp *E* down and plunger *D* pushes up on clamp *E* through the plunger *G*. The wedge angle between plungers *C* and *D* should be less than that between plungers *A* and *C*. There is considerable friction in this mechanism.